



FCW NI60WC

*Hardfacing cored wire
With tungsten carbides*

Classification

EN 14700 : T Ni20

Description & Applications

Flux cored wire for gas (Ar + CO₂) metal arc hardfacing of components requiring extreme abrasion resistance combined with corrosion. Ni-Cr-B-Si matrix. Optimised combination of toughness and wear resistance due to the heterogeneous weld metal composed of tungsten carbides distributed in a hard matrix. Excellent wetting characteristics. Could be also use with shielding gas.

Main applications: Dust extracting ventilators (mining, steel industries), components for agriculture

Typical Chemical Composition (%)

Fused Tungsten Carbide 50-60 (depending on diameter)	Ni Rem.
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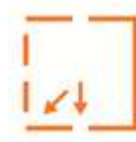
All Weld Metal Mechanical Properties

Hardness (1 st layer) 52 - 62 HRC as welded	Hardness (2 nd layer) 60 - 64 HRC as welded
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Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = +	1.6	120 - 180	19 - 22	25 - 40	ISO 14175 : M21 (Ar + CO ₂) 10-20 l/min

Surfaces to be welded should be free of rust, scale, oil or any other contamination, work with low heat input to avoid melting or sinking of the tungsten particles



FT En-CM38-180925

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